

Date: Thursday, 20/11/2008 3:34:21 PM
User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BACK FRAME ASSEMBLY	
Job Number :	43601	Part Number :	D3017041	
Estimate Number :	11129	Drawing Number :	D3017 REV A	
P.O. Number :		Project Number :	N/A	
This Issue :	20/11/2008	S.O. No. :		
Prsht Rev. :	NC	Drawing Revision :	A	
First Issue :	//	Type :	LARGE FAB ASSY	
Previous Run :	43380	Material :		
Written By :		Due Date :	20/12/2008	Qty: 1 Um: Each
Checked & Approved By :	<u>JWD 08.11.21</u>			
Comment :	Est. A 01.09.19 New Issue EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M4130NT0750W049	4130 RD Tube .750 x.049W
Comment: Qty.: 13.1250 f(s)/Unit Total : 13.1250 f(s) 4130 Tube .750 OD x.049W ✓ Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall M103012 → 11' Batch: A103012 , M10133 → 6' 30" EL 9-1-15		
2.0	D30177	Lug
Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) Lug ✓ Pick: Qty Part Number Description Batch 3 D3017-7 Lug B38567 EL 9-1-15		
3.0	D301711	cap
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) cap ✓ batch: B42354 EL 9-1-15		
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 1-Cut all tubes as per Dwg D3017 2-Bend tube as per dwg D3017 3-Drill holes in D3017-5 Using DT8622 4-Deburr EL 9-2-06		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 20/11/2008 3:34:21 PM
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Drawing Name: BACK FRAME ASSEMBLY

Job Number: 43601

Part Number: D3017041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598

A/R 4130 Rod Batch: M15684

6-Drill holes in back frame using back panel drill jig DT8621

EL 9-1-15

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 9-2-25

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

So 9/2/25

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 8:30am

OVEN TEMPERATURE: 320°F

FINISH TIME: 9:00am

MA 09-02-26

(RV)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-02-26

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 67A

CP 09/02/26

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/26

Job Completion



mt 09-02-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

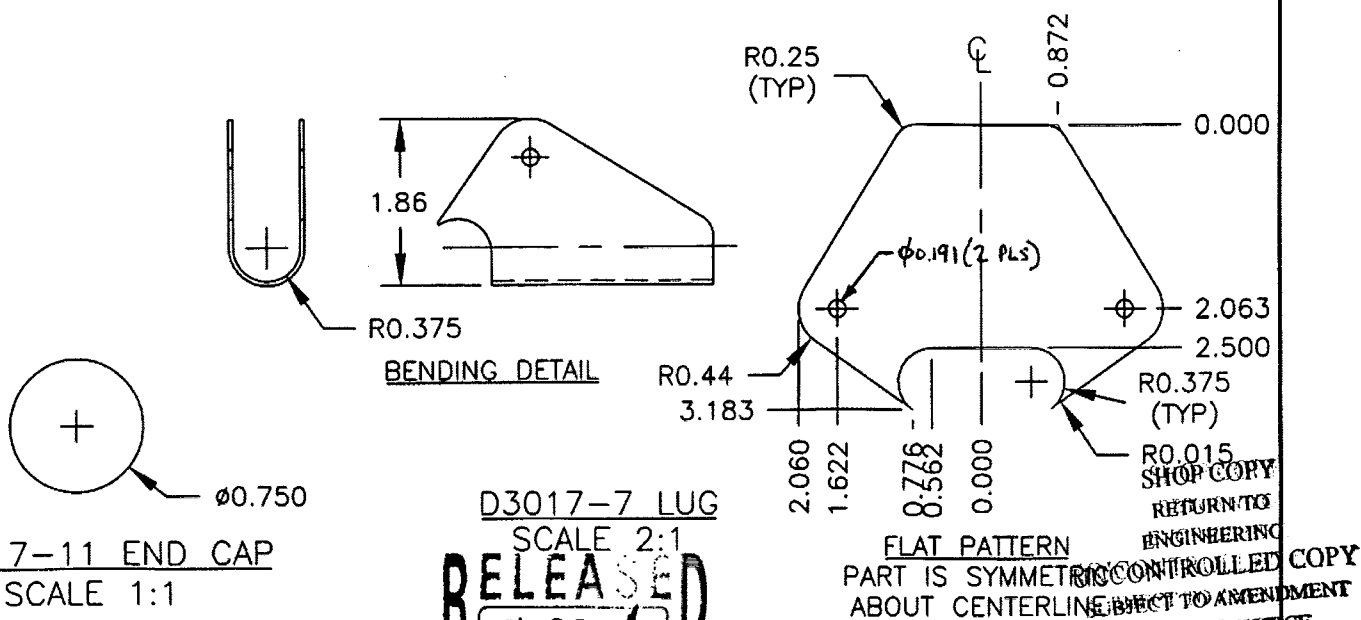


DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE 01.05.18		TITLE BACK FRAME ASSEMBLY	SCALE 1:1
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

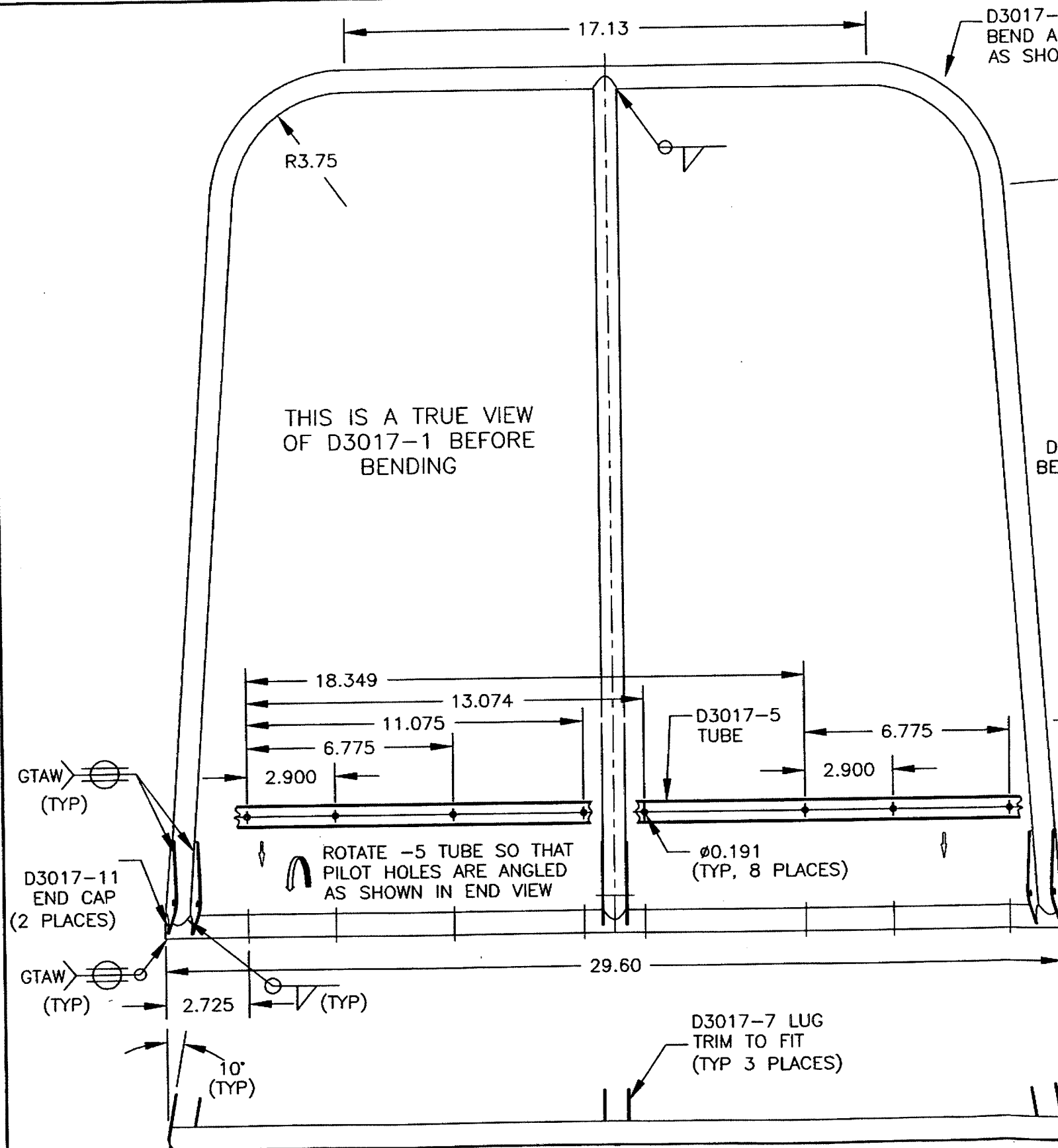
NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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D3017-1 TUBE,
BEND AND CUT
AS SHOWN

17.92
DIST BETWEEN
BEND TANGENTS

DRILL $\phi 0.128$ HOLES TO LINE UP
WITH D3023-1 BACK PANEL

22.05

27.89

R4.00

14.9°

26.2°
ANGLE
TO HOLE
CENTERLINE

R0.38
(TYP)

21.30

27.14

R4.00

14.9°

D3017-3 TUBE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4801

RELEASED
01-06-07

D3017-041 BACK FRAME ASSEMBLY
(D3017-1 TUBE, D3017-5 TUBE)

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DESIGN

CP

DRAWN BY

CP

DART

DART AEROSPACE LTD.
HAVERSBURY, ONTARIO, CANADA

CHECKED

#

APPROVED

#

DRAWING NO.

D3017

REV. A

SHEET 2 OF 2

DATE

01.05.18

TITLE

BACK FRAME ASSEMBLY

SCALE

1:4